



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D205-634-041
Job Sheet 198771



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Description:

Type: Stock

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VER:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VER:FJS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		8/30/19	0.00	0.65	Skidtubes - Bend		M6rk
120	Skidtubes - 2 - B4B	1 pcs		8/30/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		TF
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		8/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		SB
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



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Container No: S206759



Part: D205-634-041

Job No: 198771

Serial No/Batch: S206759

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3, FAA STC SR005631

140 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00 3.00	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	8/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	8/30/19	0.00 1.31	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 -	

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AUG 29 2019

				B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 Powdercoat - 1 White Gl(A)- B4B	1 pcs	8/30/19	0.00 0.34	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 QC 3	1 pcs	8/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
200 Handfinish - 4-1-Assembly- B4B	1 pcs	8/30/19	0.00 1.00	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
210 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

Plex 8/6/19 11:48 AM Dart.lajeunesse.marie

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
220	Packaging 3-1 - Stock - B4B	1	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
225	DC - 1 - B4B	1	8/30/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
230	QC 21 - FG	1	8/30/19	0.00 0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	
					QC 21 - FG - 53	

DAS

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SEP 06 2019

9-09

M.B.

9/11/19
2019

DAS

21

9-09

SEP 10 2019

DAS

21

9-09

SEP 10 2019

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube

120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert
 D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube

AK
12/20/19

expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Debur 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 520625 Sikaflex expire date: 20/67 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 520625 Sikaflex expire date: 20/67 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5196104

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

FG 108.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skiddtubes - Bend - 1	5198059
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skiddtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skiddtubes - 3 - B4B	5184097
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5190021
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149158
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5209364
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5196148
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173297
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5128188
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201764
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196227
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201528
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201653
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178378

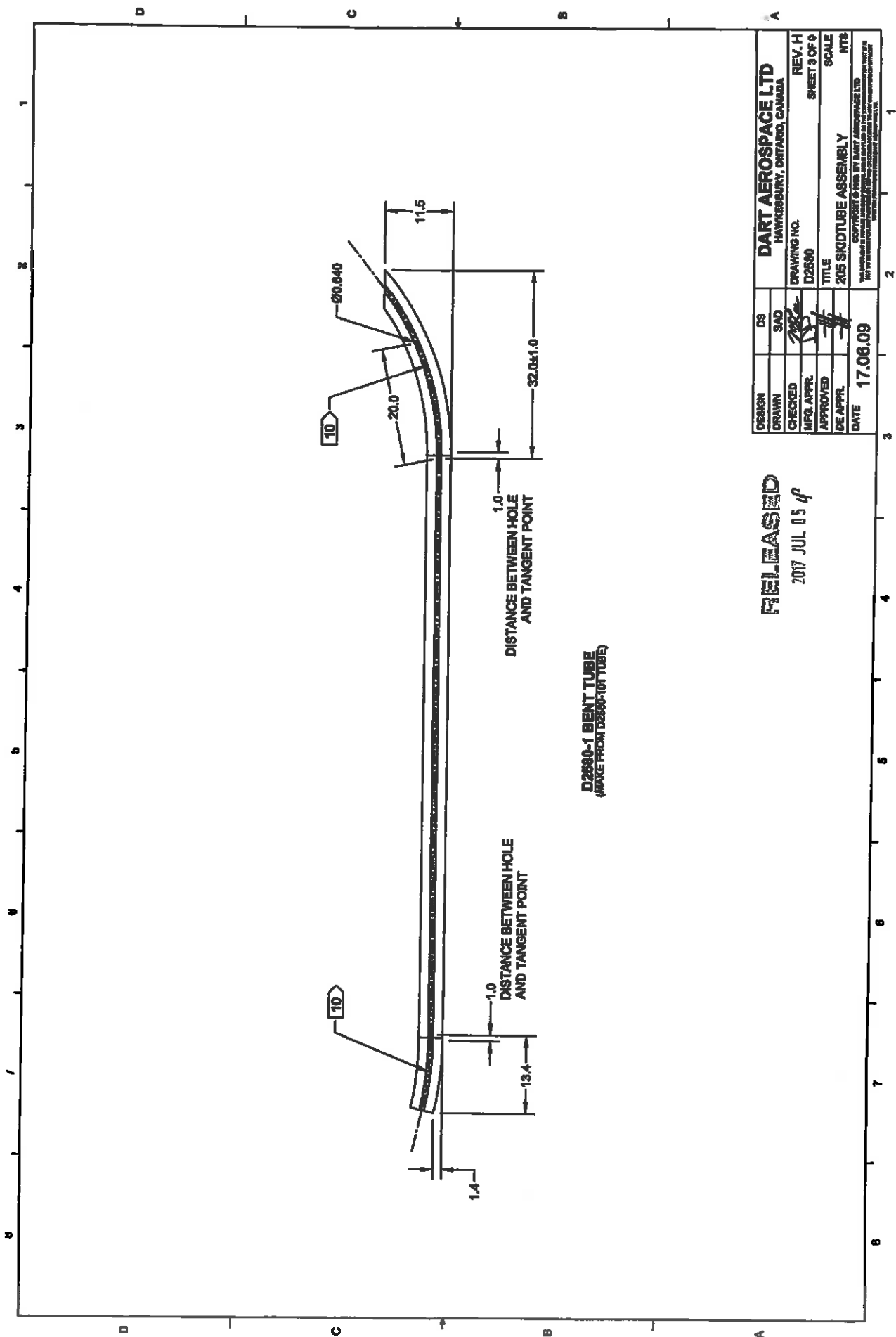
M. U. 011757

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skiddtubes - Bend - 1	D2580-1	1	4	0
140-Skiddtubes - 3 - B4B	D2576-3	1	78	0
	D4202-1	20	861	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,256	0
	AN3-5A	2	84	0
	AN3C4A	50	1,293	0
	D2594-1	16	170	0
	D2594-3	16	195	0
	D2855	1	93	0
	D3564-11	1	27	0
	D3564-13	1	16	0
	D3564-5	1	16	0
	D3564-9	1	18	0
	NAS1149C0332R	50	3,456	0
	NAS1149D0332J	2	2,549	0

Part Specifications

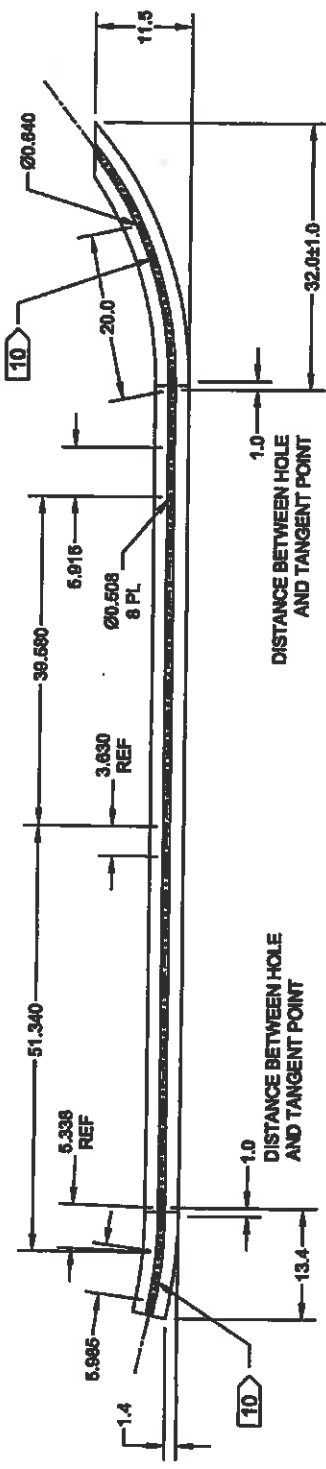
Specifications could not be found.



DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D2880 SHEET 3 OF 9
APPROVED		TITLE SCALE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY NTS

RELEASED
2017 JUL 05 4p

1 2 3 4 5 6 7 8



D2580-3 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2017 JUL 05 *no*

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAYESBURY, ONTARIO, CANADA	
CHECKED	<i>me</i>	DRAWING NO.	REV. H
INFO. APPR.	<i>me</i>	D2580	SHEET 8 OF 9
APPROVED	<i>me</i>	TITLE	SCALE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY	NTS

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1 2 3 4 5 6 7 8



Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date :	Sequence #:		QTY Affected :		MRB (QSI042)		
Description Work Order Deviation			Disposition				
Completed By			Lead hand / Supervisor				
QC / QA Coordinator							

Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread									
		Other/Details:									